

Date: Monday, 2/4/2008 11:25:03 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 37167
 Estimate Number : 11683
 P.O. Number :
 This Issue : 2/4/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2888
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2888 REV A2
 Previous Run : 36071 Project Number : N/A
 Material : A
 Due Date : 2/28/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. C 00.06.22 Removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X03500 6061-T6 Bar 2.5" x 3.5"



Comment: Qty.: 0.3938 f(s)/Unit Total : 4.7250 f(s)

6061-T6 Bar 2.5" x 3.5"

Material: 3.5" x 2.5" bar 6061-T6

Batch M102838

mm 08/05/24

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 4.20" long

(Grain along 4.20")

mm 08/05/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2888

Deburr and Tumble

JA 08/05/26

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 08/05/26

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JA 08/05/29

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

20/F2 08/06/02

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2888 PAR #: NA Fault Category: Prod / Machined Parts NCR: (Yes) No DQA: D Date: 08/06/04
D412-666-011 QA: N/C Closed: D Date: 09/04/05

NCR: <u>37167</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/05/26</u>	<u>3</u>	<u>- 2 parts are scrapped blanks were cut too short, was not able to clean outside profile</u>	<u>[Signature]</u> <u>08/10/02</u>	<u>- scrap + replace <u>B102838</u></u>	<u>J.L</u> <u>08/05/26</u>	<u>[Signature]</u> <u>080520</u>	<u>[Signature]</u> <u>08/10/02</u>	<u>[Signature]</u> <u>080520</u>

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:25:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 37167

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



m107925

start time: 2:30



(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Temperature: 320°

Finish time: 3:00

FX 08/06/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08-06-02

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SY 2470

AS 08/06/03

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-06-03

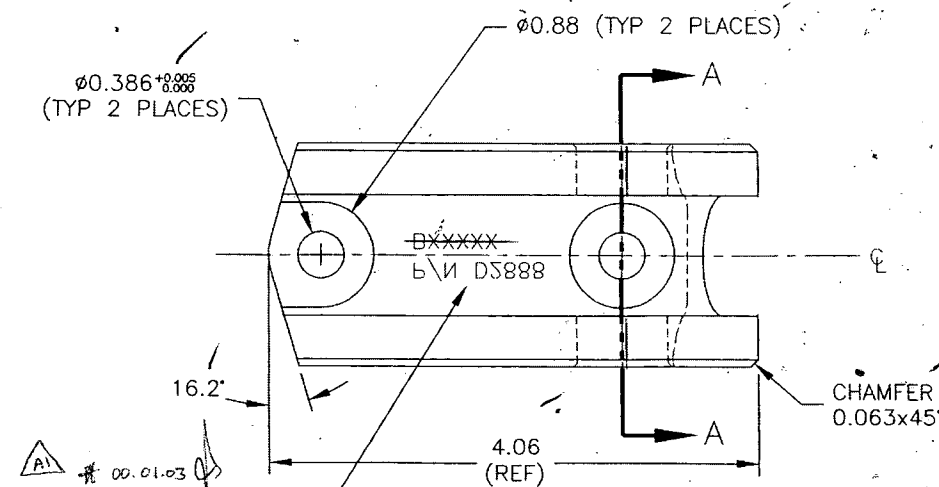
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ENGRAVE DART PART NUMBER AND BATCH NUMBER IN THIS AREA ON BOTTOM SURFACE

ENGRAVE DART LOGO IN THIS AREA, 0.50 HIGH x 0.010 DEEPLLETTERING

CP 00.10.31

0.080x45° CHAMFER

0.438

2.75

2.500

3.28

NO. 37167

WORK ORDER

37167

CONTROLLED COPY

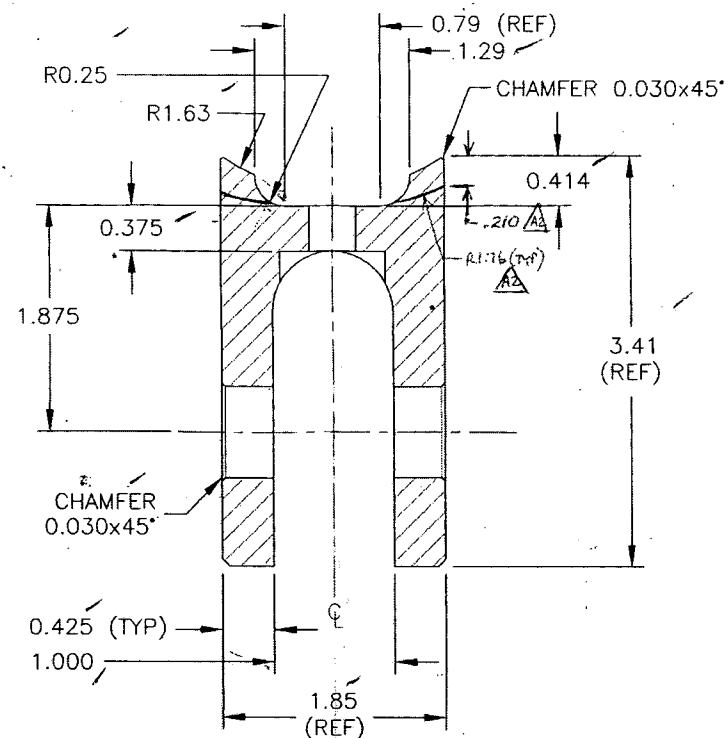
RETURN TO

ENGINEERING

SUBJECT TO AMENDMENT

WITHOUT NOTICE

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SECTION A-A
SCALE 1:1

RELEASED
97.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD MANNESBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	TITLE	REV. A SHEET 1 OF 1
99.06.21	LUG	SCALE 1:1

A2	04.04.08	Add Saddle Clearance Per NCR 754
A1	00.10.31	Update Engraving 00.10.31 CP

2.284

DART AEROSPACE LTD		Work Order: 37167
Description: lug		Part Number: D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.386	+ .005 - 0	.388	✓			
.88	+ - .030	.879	✓			
.063X45°	+ - .010	.055X45°	✓			
4.06	+ - .030	4.075	✓			
.760	+ .005 - 0	.763	✓			
3.48	+ .030	3.480	✓			
2.500	+ - .010	2.500	✓			
2.750	+ - .030	2.760	✓			
.438	+ - .010	.434	✓			
.080X45°	+ - .010	.090X45°	✓			
1.85	+ - .030	1.854	✓			
1.000	+ - .010	1.006	✓			
.425	+ - .010	.423	✓			
.03X45°	+ - .010	.025X45°	✓			
1.875	+ - .010	1.870	✓			
.375	+ - .010	.377	✓			
1.25	+ - .030	.250	✓			
1.29	+ - .030	1.291	✓			
.414	+ - .010	.406	✓			
3.410	+ - .030	3.415	✓			

Measured by: SL	Audited by: SA	Prototype Approval: N/A
Date: 08/05/26	Date: 08/05/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	